

Work Order ID 135394

135394

Page 1

Wednesday, August 12, 2015 4:26:41 PM

Item ID: D2480-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Handle Weldment LH
 Start Date: 8/12/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/12/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: AUG 13 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2480	Rev A1								

100 Large Fab 0.00
100
 Large Fab Memo 0.03
 Large Fab Weld as per Template DT 8333 (DT 2480 CJ) 3 15-10-06

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00 (3) 15-10-07 **DAS**
 Quality Control **9**
9-89

120 QC5- Inspect part completeness to step on W/O 0.00
120
 QC Memo 0.00 (3) 15-10-07 **DAS**
 Quality Control **9**
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

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Page 2

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>m 132729</i> Memo START TIME: <i>9:30</i> <i>7:00</i> FINISH TIME: <i>12:00</i>	0.00 0.00				<i>3</i>	<i>0</i>	<i>15-10-7</i>	<i>8 3 8</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							<i>3</i> DAS 38 9-89 OCT 27 2015
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>Ship</i> Memo	0.00 0.00				<i>3</i>		<i>OCT 07 2015</i>	DAS 86 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																							
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Misidentified ☐	Past Due ☐																																																														

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Page 3

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Item ID: D2480-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Handle Weldment LH

Start Date: 8/12/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/12/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCS

OCT 07 2015

MCS OCT 07 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 135394

135394

Parent Item: D2480-011

D2480-011

Parent Item Name: Handle Weldment LH

Start Date: 8/12/15

Required Date: 8/12/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B1 03.01.09 added Powder Coat

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2478

Manufactured

No

100

Each

6.0000

1

2

D2478

Heli-Access Handle

**

Q 15-10-5

Location

Loc Qty

Loc Code

WA002

6

119314

2

135068

4

D2479

Manufactured

No

100

Each

5.0000

1

2

D2479

Heli-Access Handle

**

Q 15-10-5

Location

Loc Qty

Loc Code

WA002

5

119315

1

135069

4

D2481

Manufactured

No

100

Each

29.0000

2

4

D2481

Mounting Plate

**

Q 15-10-5

Location

Loc Qty

Loc Code

WA002

29

119318

29

D2482

Manufactured

No

100

Each

14.0000

1

2

D2482

Mounting Plate

**

Q 15-10-5

Location

Loc Qty

Loc Code

WA002

14

122891

10

30370

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

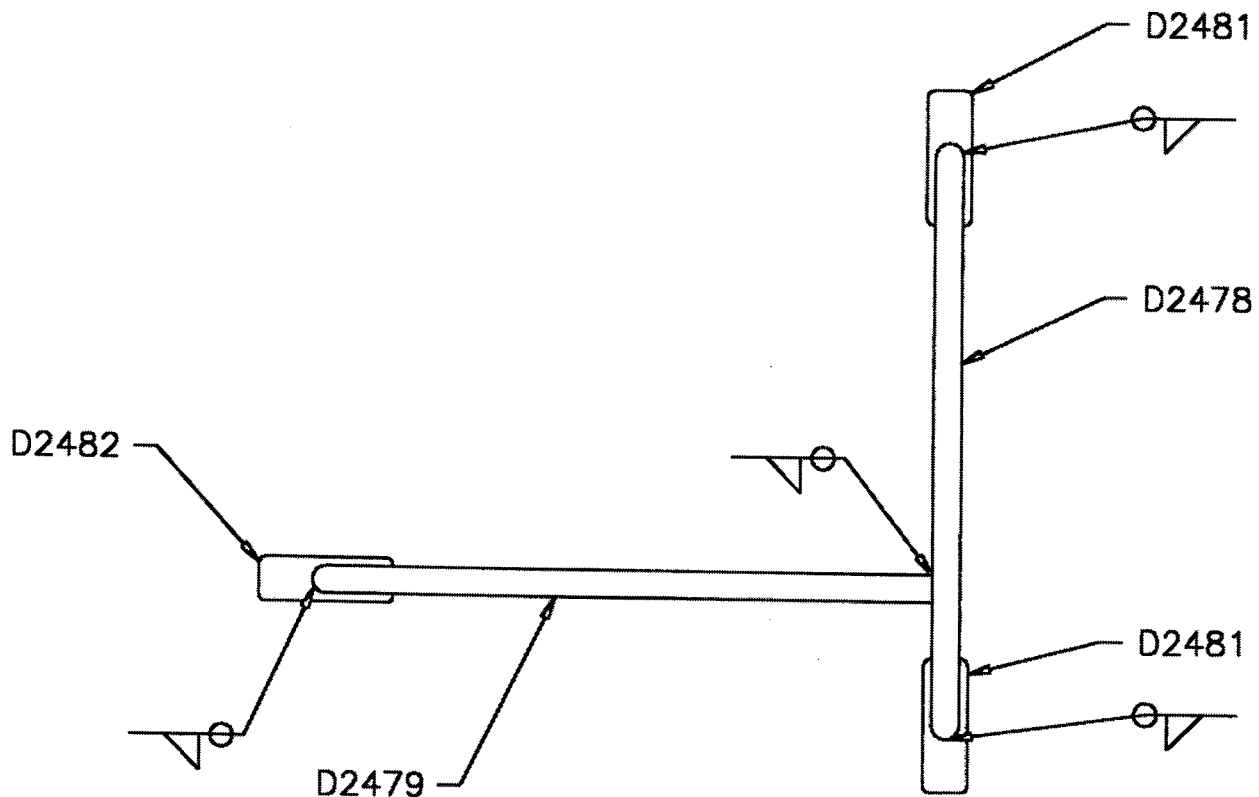
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED	APPROVED	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1		ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

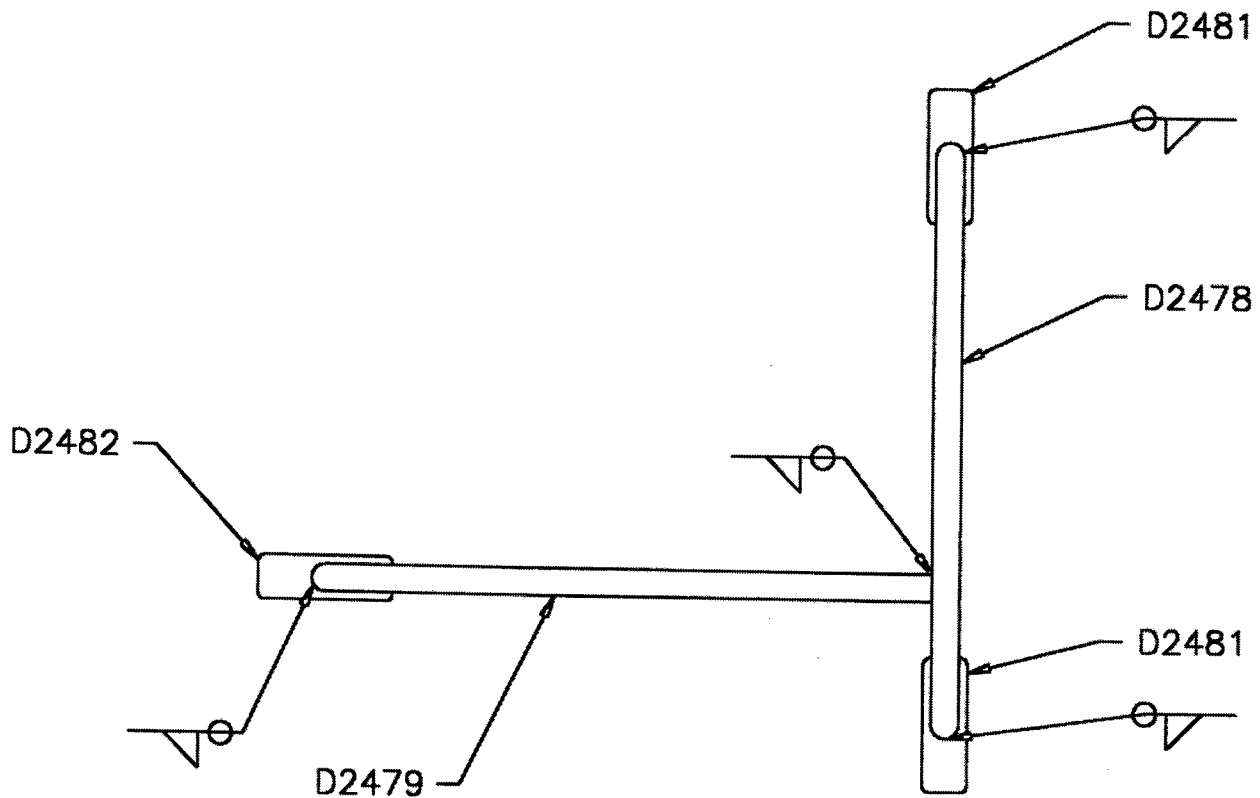
- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

STOP COPY
RETURN TO
ENGINEERING
UNICORP LTD COY
SPECIAL PROJECT
WORK CENTER
NO. 135394 MJS
15-08-13



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1	05.06.23	ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

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A1 2) POWDER COAT WHITE GLOSS (REF: 4,3,5,2) AS PER QSI 005